

ABSTRACT

A porcelain enamel composition having a metallic appearance is disclosed. The composition comprises about 45% to about 55% SiO_2 , about 4 to about 20% R_2O , about 9 to about 15% B_2O_3 , about 4 to about 12% MnO_2 , about 1.5 to about 7% F_2 , about 0% to about 20% MO_2 , about 0% to about 10% RO , about 0% to about 6% NO_2 , about 0% to about 2% P_2O_5 , about 0% to about 3% CoO , about 0% to about 3% NiO , about 0% to about 3% Al_2O_3 , about 0% to about 3% Fe_2O_3 , about 0% to about 3% CuO , about 0% to about 4% ZrO_2 , about 0% to about 2% Nb_2O_5 , and about 0% to about 5% Sb_2O_3 , wherein R_2O represents at least one alkali oxide, wherein RO represents at least one alkaline earth oxide and wherein MO_2 represents at least one opacifying pigment selected from the group consisting of ZrO_2 , TiO_2 , CeO_2 , SnO_2 and La_2O_3 .